

Work Order ID 129589

February-18-15 8:00:07 AM

650.9201
B129589
REV. N/C

129589

Page 1

Item ID: 650.9201

Revision ID:

Item Name: Eyelet Bracket Assembly

Start Date: 2/18/15

Start Qty: 3.00

3

Required Date: 3/06/15

Req'd Qty: 3.00

3

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
650.9200	n/c

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 2.200"

4 0 BC
15.02.26

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB361

DWG REV: N/C

FOLIO REV: N/C

2- deburr and break all sharp edges

4 0 15/02/26

February-18-15 8:00:07 AM

Page 2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Eyelet Bracket Assembly

Start Date: 2/18/15 **Start Qty:** 3.00

3

Cust Item ID:

Required Date: 3/06/15 **Req'd Qty:** 3.00

3

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS
14
9-89

9-89
15/03/02

Work Order ID 129589

February-18-15 8:00:07 AM

129589

Page 3

Item ID: 650.9201 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Eyelet Bracket Assembly
Start Date: 2/18/15 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 3/06/15 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O to ATG : <u>27605</u>								
	1- Black Anodize as per Dwg 650.9200								
	2- PRIME AS PER DWG, SEE NOTE #2*****MASK THREADS BEFORE PRIMING*****								
	Certification of Comformity is required								
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									

Cd 15/03/02 (4)

Y

MAR 04 2015

DAG
06
9-88

Work Order ID 129589

February-18-15 8:00:07 AM

129589

Page 5

Item ID: 650.9201 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eyelet Bracket Assembly
 Start Date: 2/18/15 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MCD 15-03-04

15.3-4

Picklist Print

February-18-15 8:00:06 AM

Page 1

Work Order ID: 129589

129589

Parent Item: 650.9201

650 9201

Parent Item Name: Eyelet Bracket Assembly

Start Date: 2/18/15

Required Date: 3/06/15

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 15-01-08 JLKM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B1.000x2.500		Purchased	No				f	12.0000		1			

M7075T6B1 000x2 500

7075-T6 Bar 1.000 x 2.500"

Location	Loc Qty	Loc Code
MAT	12	
m131321	12	

MS21209F5-20

Purchased

No

Each

100.0000

MS21209F5-20

Heli Coil

Location	Loc Qty	Loc Code
ST299	100	
m131267	100	

0.75 36 15-02-20
3
15/03/04 DAS
36
9-89
4

DART AEROSPACE LTD		Work Order:	179589
Description: EYELET BRACKET ASSY		Part Number:	650.9201
Inspection Dwg: 650.9200 Rev: N/C			Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:	<i>[Signature]</i>	Checked by:	14	QC Inspector:	
Date:	15/02/26	Date:	15/03/22	Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF DART AEROSPACE DBA APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE DBA APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	INITIAL RELEASE	11-19-14	P. BRAVO

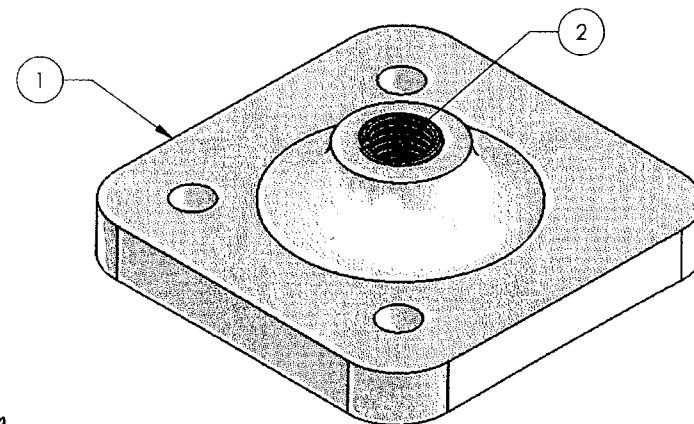
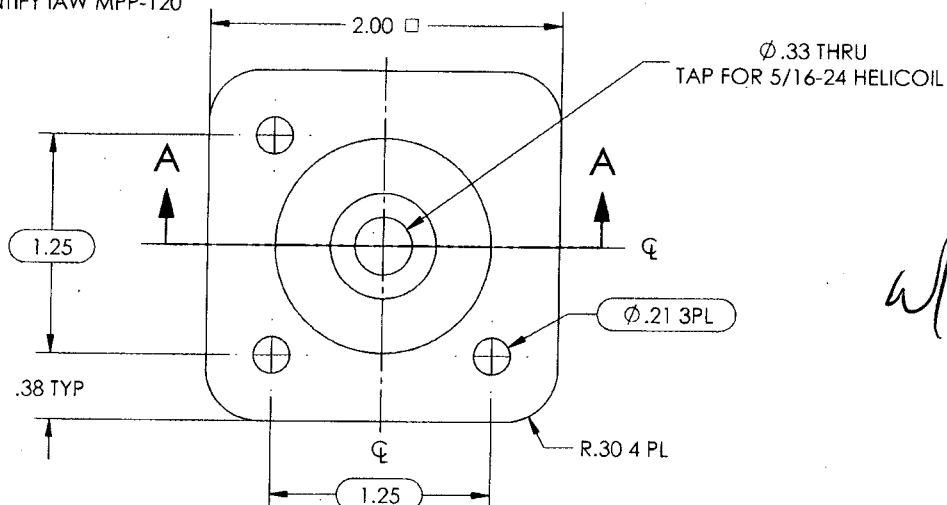
1 PART DIMENSION CONTROLLED BY 3D CAD MODEL
F/N 1 CONTROLLED BY "650.9210 EYELET BRACKET.SLDPRJT"
LAST MODIFIED: 11-17-14

2 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12

3 FINISH: IAW MPP-172 ANODIZE IAW SECTION 2.1,
PRETREATMENT IAW SECTION 3.2,
PRIMER IAW SECTION 4.3.

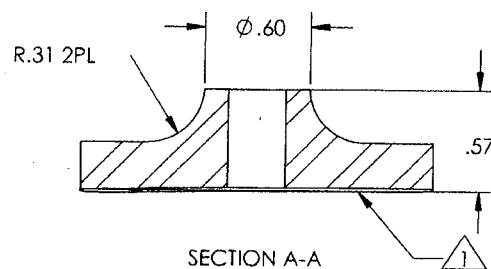
4. BREAK AND DEBURR ALL SHARP EDGES

5. IDENTIFY IAW MPP-120



W/0129589

650.9201



1	2	601.2746	HELICAL INSERT	MS21209F5-20	
1	1	650.9210	EYELET BRACKET		
		650.9201	EYELET BRACKET ASSY		
FIND #	PART #	DESCRIPTION	MAT'L	SPEC.	
BOM Table					
PARTS LIST					
QTY	ORIGINAL DATE	DESIGNED BY	CHECKED BY	DART 3030 ENTERPRISE CT., SUITE A AEROSPACE VISTA, CA. 92081 APICAL INDUSTRIES INC. (760)-724-5300 2500 DART AEROSPACE	
NEXT ASSY (S)	11-19-14	1-10-10	P. BRAVO		
646.4000					
EYELET BRACKET ASSY				SRE	REV.
				8	N/C
				07M26	650.9200
				SCALE	NONE
				SHEET 1 OF 1	



A.T.G. Industries Inc.
 731, rue Industrielle Rd.
 PLATING DEPARTMENT
 Rockland, On K4K 1T2
 Canada
 Ph: (613) 446-4544
 Fax: (613) 446-4556

Pack List

Number: 63569

Date: 04-Mar-15

To

DART AEROSPACE LTD
 1270 ABERDEEN ST.
 HAWKESBURY, ON K6A 1K7
 Canada

Ship To

DART AEROSPACE LTD
 1270 ABERDEEN ST.
 HAWKESBURY, ON K6A 1K7
 Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 ea	Part: D2224 RAPPEL ANCHOR RED ANODIZE AS PER MIL-A-8625 TY II CL 2 MINMUM RUN Job: 20150185 5 PCS	Rev: PO: PO27605 Line:	
6 ea	Part: D4726-1 HANDLE REV.A HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20150186	Rev: PO: PO27605 Line:	
4 ea	Part: 647.3917 DOUBLER HARD ANODIZE MIL-A-8625 TY III CL 2 PRIME MIL-P-23377J TYPE I CLASS N PRIMER SUPPLY CUSTOMER Job: 20150187	Rev: C PO: PO27605 Line:	
16 ea	Part: 647.4111 DOUBLER HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150188	Rev: N/C PO: PO27605 Line:	
6 ea	Part: 649.5310 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N	Rev: 	



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HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity		Description	
		PRIMER IS SUPPLY BY CUSTOMER Job: 20150189 PO: PO27605 Line:	
4 ea	Part: 650.9201 Rev: HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY CUSTOMER Job: 20150190 PO: PO27605 Line:		
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : <u>4/3/15</u> CERTIFIED SIGNATURE : <u></u> RECEIVER SIGNATURE : _____			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27605**

Purchase Order Date 2/27/2015

PO Print Date 3/3/2015

Page Number 1 of 4

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	126418	D2224 RAPPEL ANCHOR REV. E	3/5/2015 Yes 3/5/2015 FINISH: RED ANODIZE AS PER MIL-A-8625F TYPE I OR IB / IC / II / IIB CLASS 2		5.00	\$25.00	\$125.00
Line Total:							\$125.00
2	128523	D4726-1 HANDLE REV. A	3/5/2015 Yes 3/5/2015 FINISH: BLACK ANODIZE AS PER MIL-8625F TYPE III, CLASS 2		6.00	\$2.70	\$16.20
Line Total:							\$16.20

Note:

3/3/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27605**

Purchase Order Date 2/27/2015

PO Print Date 3/3/2015

Page Number 2 of 4

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

613-446-4544

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

VENDOR'S TRUCK

FOB

FCA - (Free Carrier)

Ship Acct:

3	130171	647.3917 DOUBLER REV. C	3/3/2015	4.00	\$6.60	\$26.40
---	--------	----------------------------	----------	------	--------	---------

Yes

3/3/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2

PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N

RUSH ORDER NEED BY MARCH 3

Line Total: \$26.40

4	120743	647.4111 REV. N/C	3/5/2015	16.00	\$7.90	\$126.40
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Yes

3/6/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2

PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N

Line Total: \$126.40

5	127876	649.5310 LOWER DEFLECTOR REV. C	3/5/2015	6.00	\$11.45	\$68.70
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Yes

3/5/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2

PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N

Note:

3/3/2015

15/03/15
SP



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27605**

Purchase Order Date 2/27/2015

PO Print Date 3/3/2015

Page Number 3 of 4

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Total: \$68.70

6	71401-45	PROCUREMENT QUALITY CLAUSES	3/3/2015	1.00	\$0.00	\$0.00
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No

Procurement Quality Clauses

3/3/2015

A004 FAA-PMA /TSO

A005 RIGHT OF ENTRY

A016 PERSONNEL QUALIFICATION

A024 PROCESS CERTIFICATIONS

A025 CERTIFICATE OF CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENTS

Line Total: \$0.00

7	129589	650.9201 EYELET BRACKET REV.N/C	3/4/2015	4.00	\$6.60	\$26.40
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Yes

3/4/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2
PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N

15/03/04
SF

Note:

3/3/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO27605

Purchase Order Date 2/27/2015

PO Print Date 3/3/2015

Page Number 4 of 4

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Total: \$26.40

PO Total: \$389.10


Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 3

Change Date: 3/3/2015

1	126418/D2224	RED ANODIZE	5	LOT 125.00
2	128523/D4726-1	HARD ANODIZE BLACK	6	\$2.70
3	130171/647.3917	HARD ANO BLACK/PRIME	4	\$6.60
4	120743/647.4111	HARD ANO BLACK/PRIME	16	\$7.90
5	127876/649.5310	HARD ANO BLACK/PRIME	6	\$11.45
6	129589/650.9201	HARD ANO BLACK/PRIME	4	\$6.60
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
PO27605 QUOTE ONLY				
ATG IS NOT DOING ANY Pretreatment as per cardinal's 4860-50 AND PRETREAT PRC-DESOTO PR-148				
Repeat order.				